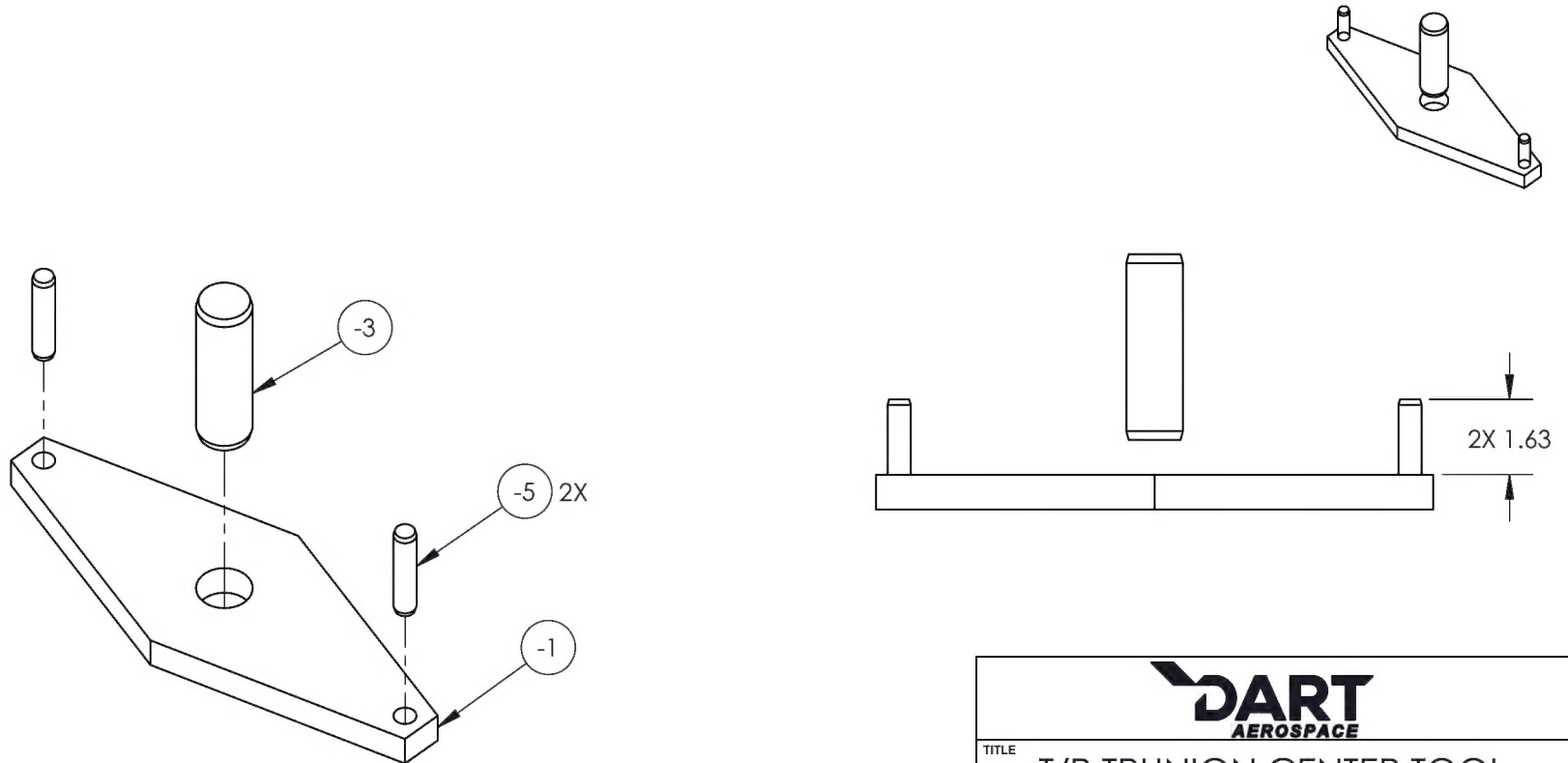


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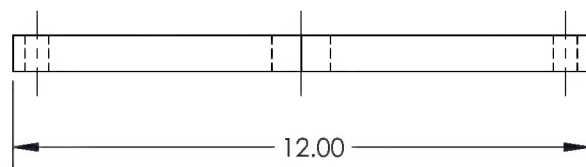
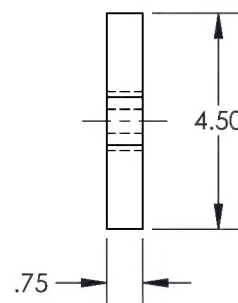
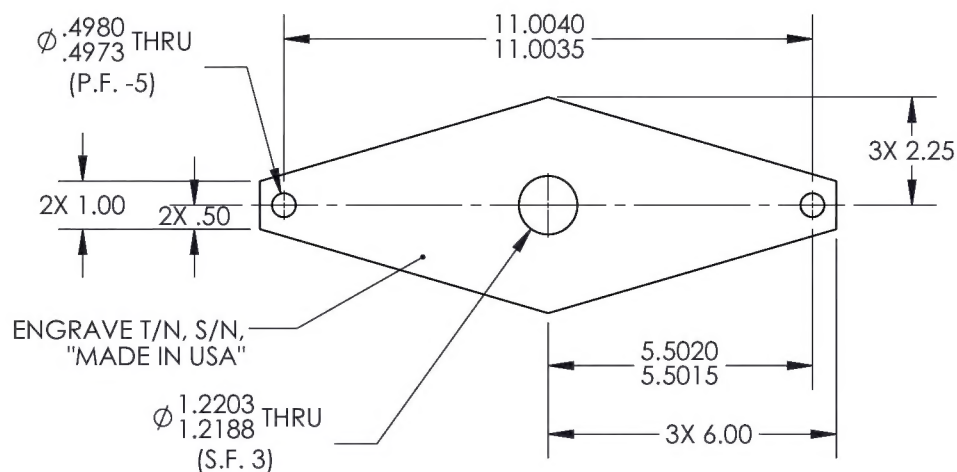
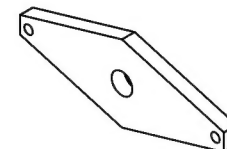
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		ADDED ENGRAVING AND PRESS FIT NOTES, ADDED ASSEMBLY DRAWING.	4/11/2007		
1A		CH'D REVISIONS FROM ALPHBETICAL TO NUMERICAL, CH'D TITLEBLOCK AND REVISION BLOCK, LABELED PARTS. -1, -3 & -5 CORRECTED P/N VIEWS. -1 CH'D ENGRAVE NOTE.	1/4/2009	RJC	RW
2	16-0232	ADDED DIM 2X 1.63. -1, -3, -5 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. -1 CH'D DIM WAS Ø.4990/.4985 (X2) IS 2X Ø.4980/.4973 (P.F. -5), WAS Ø1.2203/1.2188 IS Ø1.2203/1.2188 (S.F. -3), WAS 2.25 IS 3X 2.25, CH'D MATERIAL WAS 1018 IS A36/1018/1020 HR. -3 CH'D DIM WAS Ø1.2185/1.2180 IS Ø1.2185/1.2180 (S.F. -1), WAS .19 TYP. IS 2X .19, WAS 15° TYP. IS 2X 15°. -5 CH'D DIM WAS Ø.4990/.4985 IS Ø.4990/.4985 (P.F. -1), WAS .12 TYP. IS 2X .12, WAS 15° TYP. IS 2X 15°.	11/22/2016	RJC	JAG



<b>DART AEROSPACE</b>	
TITLE <b>T/R TRUNION CENTER TOOL</b>	
DWG NO. <b>RBT18529</b>	REV <b>2</b>
MAT'L REAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	PERRITT
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL <b>BELL 212</b>	
SCALE <b>1:4</b>	DATE <b>7/1/2005</b>
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	A36/1018/1020 HR		2
			-3	1	CENTER PIN	STRESS PROOF		3
			-5	2	PIN	01		4

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		ADDED ENGRAVING AND PRESS FIT NOTES.	4/11/2007		
1A		-1 CORRECTED P/N VIEW, CH'D ENGRAVE NOTE.	1/4/2009	RJC	RW
2	16-0232	-1 CH'D DIM WAS Ø.4990/.4985 (X2) IS 2X Ø.4980/.4973 (P.F. -5). WAS Ø1.2203/1.2188 IS Ø1.2203/1.2188 (S.F. -3), WAS 2.25 IS 3X 2.25, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D MATERIAL WAS 1018 IS A36/1018/1020 HR.	11/22/2016	RJC	JAG



① -1

BASE



TITLE	T/R TRUNION CENTER TOOL
-------	-------------------------

DWG NO. RBT18529-1

RE 2

MAT'L	A36/1018/1020 HR
-------	------------------

HEAT  
TREAT

TREAT	
FINISH	BLACK OXIDE

SPEC	QMSI-6.2.2, B.O. REV D
------	------------------------

DRAWN BY:	PERRITT
-----------	---------

CHECKED:	DUERFELDT
----------	-----------

OPPS APPR:	ANDERSON
------------	----------

	ANDERS
QA APPR:	LINDSAY

APPROVED:	GILBERT
-----------	---------

SCALE	1:4
-------	-----

	UNLESS OTHERWISE SPECIFIED
--	----------------------------

DIMENSIONS ARE IN INCHES  
XXX + .005 FRACTIONS ± 1/8

.XXX	± .005	FRACTIONS ± 1/8
.XX	± .01	ANGLES ± .5°
.X	± .1	SURFACES ± .125

.X ± .1 SURFACES = 125 ✓  
1. BREAK ALL SHARP EDGES

1. BREAK ALL SHARP EDGES  
.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

ASME Y14.5M-2009	
	USED ON MODEL

	USED ON MODEL
	BELL 212

1/1/2005 SHEET 2 OF 4

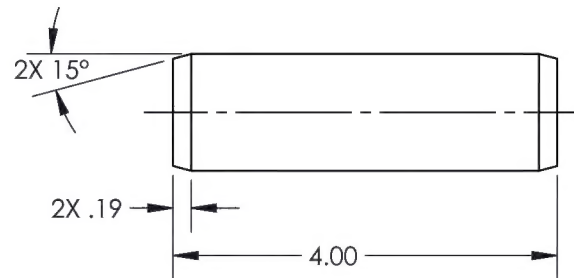
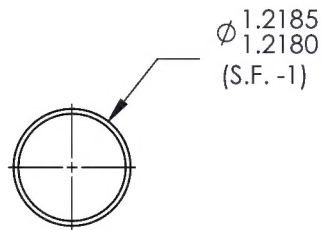
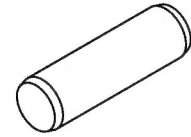
SCALE	1:4
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DATE	7/1/2005
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SHEET 2 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1A		-3 CORRECTED P/N VIEWS.	1/4/2009	RJC	RW
2	16-0232	-3 CH'D DIM WAS Ø1.2185/1.2180 IS Ø1.2185/1.2180 (S.F. -1), WAS .19 TYP. IS 2X .19, WAS 15° TYP. IS 2X 15°, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	11/22/2016	RJC	JAG



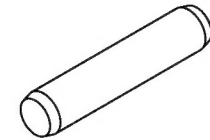
(-3)

CENTER PIN

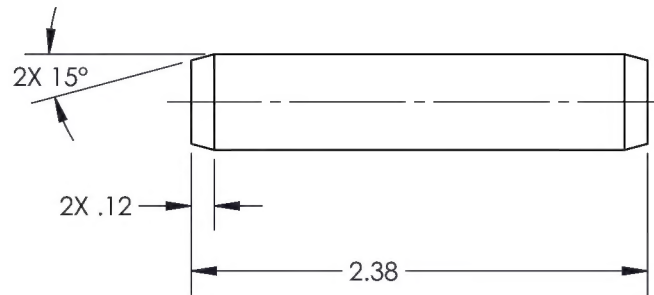
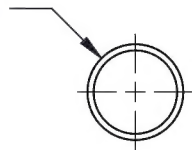
<b>DART</b> AEROSPACE	
TITLE <b>T/R TRUNION CENTER TOOL</b>	
DWG NO. <b>RBT18529-3</b>	REV <b>2</b>
MAT'L STRESS PROOF	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 7/1/2005
	SHEET 3 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1A		-5 CORRECTED P/N VIEW.	11/22/2016	RJC	RW
2	16-0232	-5 CH'D DIM WAS Ø.4990/.4985 IS Ø.4990/.4985 (P.F. -1), WAS .12 TYP. IS 2X .12, WAS 15° TYP. IS 2X 15°, ADDED FINISH SPEC QMSI-6.2.2, B.O., REV D.	11/22/2016	RJC	JAG



Ø.4990  
Ø.4985  
(P.F. -1)



(-5)

PIN

<b>DART AEROSPACE</b>	
TITLE <b>T/R TRUNION CENTER TOOL</b>	
DWG NO. <b>RBT18529-5</b>	REV <b>2</b>
MAT'L 01	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: PERRITT	.X ± .1 SURFACES = 125✓
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/1/2005	USED ON MODEL
	BELL 212
	SHEET 4 OF 4